Work Order ID 72223

Wednesday, July 20, 2011 8:04:23 AM

Item ID: D4020-11 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: End Mesh, Basket

Start Date: 7/20/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 7/26/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/07/20 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4020	A								
100	FLOW WATER JET	0.00	11/07/20			6			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4020 Dwg Rev: A Prog Rev: A 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00	11/07/20			6			
QC	**Memo**	0.00							
Quality Control	***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET***								
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control	***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET***								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 72223

Wednesday, July 20, 2011 8:04:23 AM

Item ID: D4020-11

Revision ID:

Item Name: End Mesh, Basket

Start Date: 7/20/2011 **Start Qty:** 6.00

Required Date: 7/26/2011 **Req'd Qty:** 6.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: BC	0.00							
Packaging						MB	11/08/03		
Packaging	Memo	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
QC						CK	11/08/04		
Quality Control	Memo	0.00							

11-08-2
CK

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 20, 2011 8:04:20 AM

Work Order ID: 72223

Parent Item: D4020-11

Parent Item Name: End Mesh, Basket

Start Date: 7/20/2011 **Required Date:** 7/26/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP RevA: new issue DD 09.11.26 verified by;EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C 10.06.14 remove cut out from dxf, will be made when install on basket DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			100	sf	746.2424	2.694	17.01474			

Location		Loc Qty	Loc Code
MAT		11.5607	
	117708	11.5607	
WA		734.6817	
	115012	95	
	117197	102.9036	
	117455	16.0341	
	117896	102.1046	
	~~118153~~	98.6394	
	118248	320	

17.5 11/07/20

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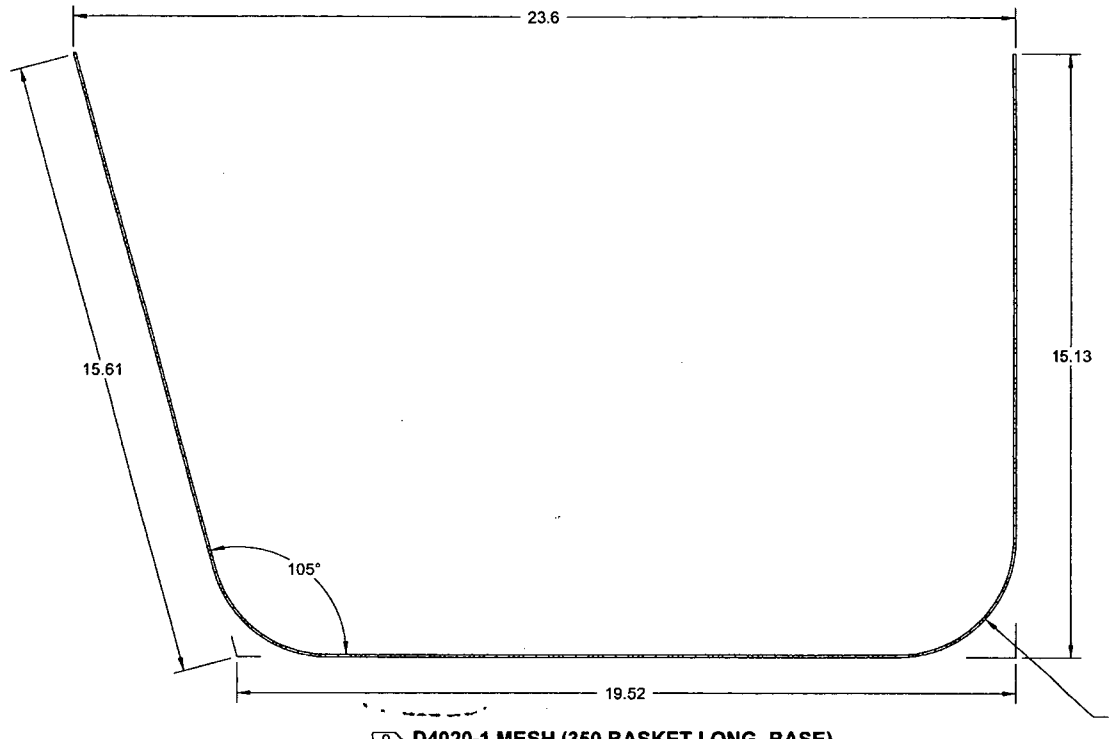
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



9 **D4020-1 MESH (350 BASKET LONG, BASE)**
(SEE D4020-1F FOR LENGTH)

9 **D4020-3 (350 BASKET SHORT, BASE)**
(SEE D4020-3F FOR LENGTH)

CL 11/07/20
W 10:72223

RELEASED
2010 -03- 12

NOTES:
1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: SEE D4020-1F & D4020-3F
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	JPH	10.03.04

DESIGN	AJS
DRAWN	JPH
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.03.04

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4020 — REV. A — SHEET 1 OF 4
TITLE: 350 BASKET MESH (BASE) — SCALE: NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

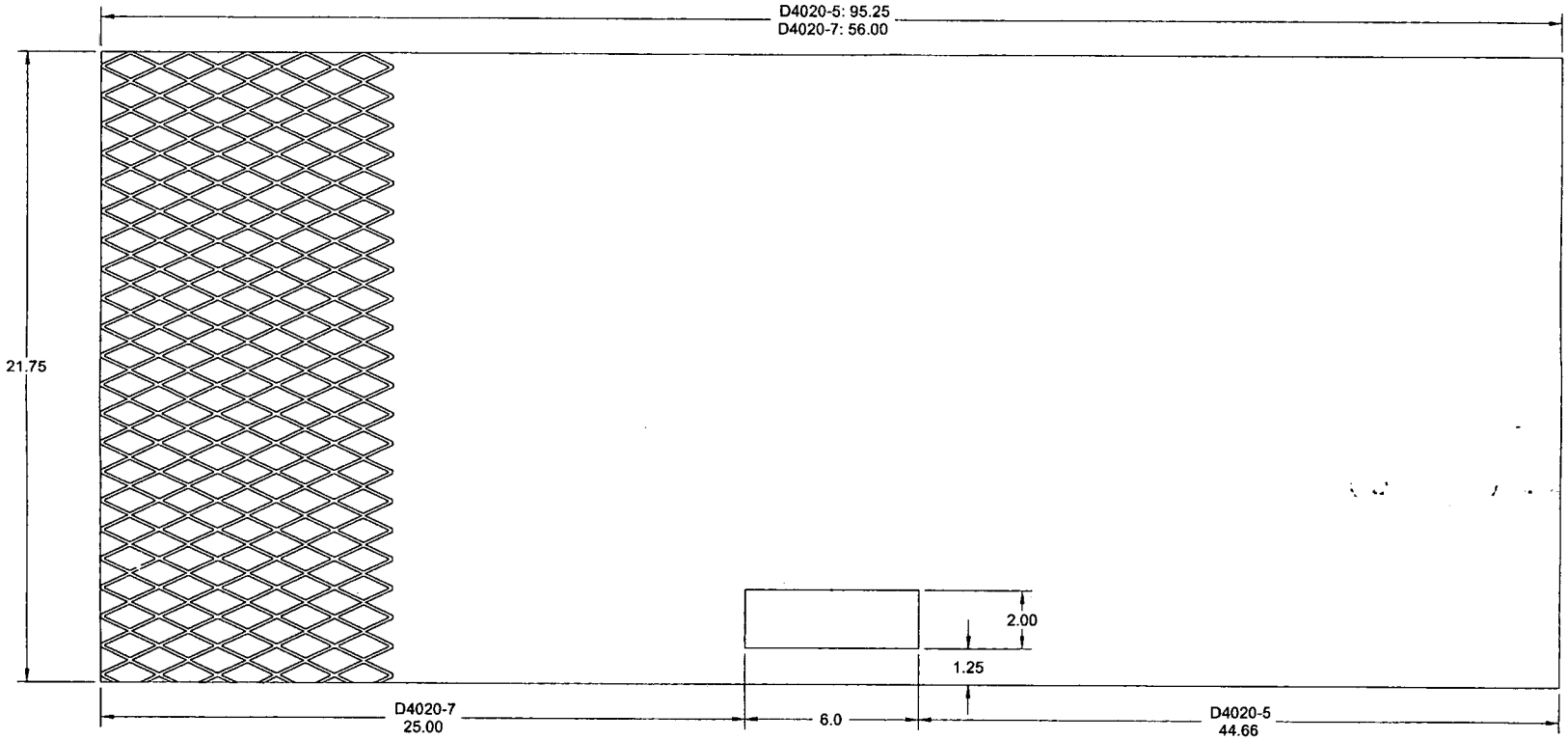
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



9 **D4020-5 MESH (350 BASKET LONG, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9 **D4020-7 MESH (350 BASKET SHORT, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010 -03- 12

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D4020 — REV. A — SHEET 2 OF 4
MFG. APPR.		
APPROVED		TITLE: 350 BASKET MESH (BASE) — SCALE: NTS
DE APPR.		
DATE	10.03.04	

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Dart Aerospace Ltd

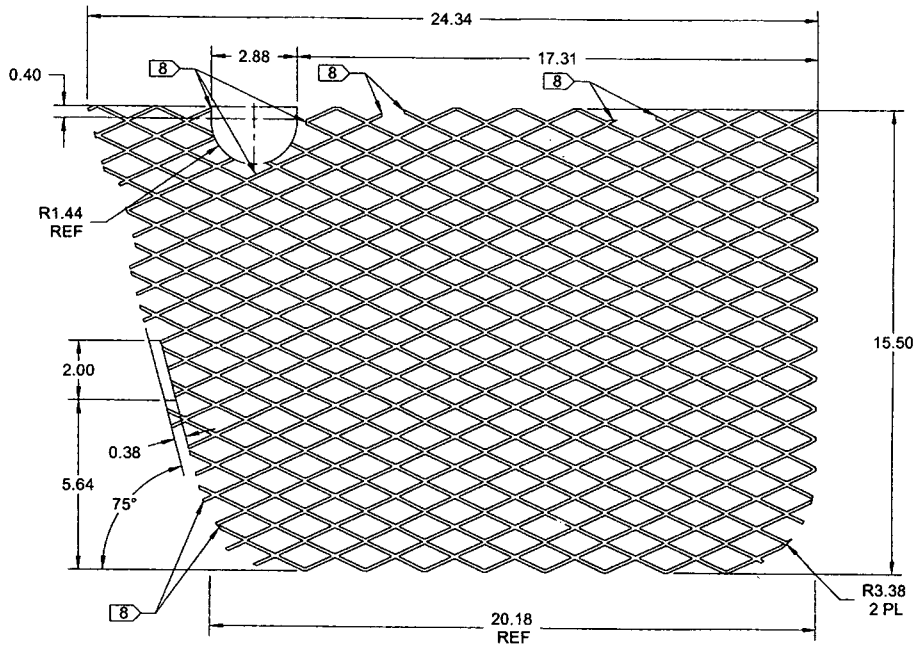
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



9 **D4020-11 END MESH, BASKET**

RELEASED
2010 -03- 12

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D4020 — REV. A — SHEET 3 OF 4
MFG. APPR.		
APPROVED		TITLE: 350 BASKET MESH (BASE) — SCALE: NTS
DE APPR.		
DATE	10.03.04	

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art Aerospace Ltd

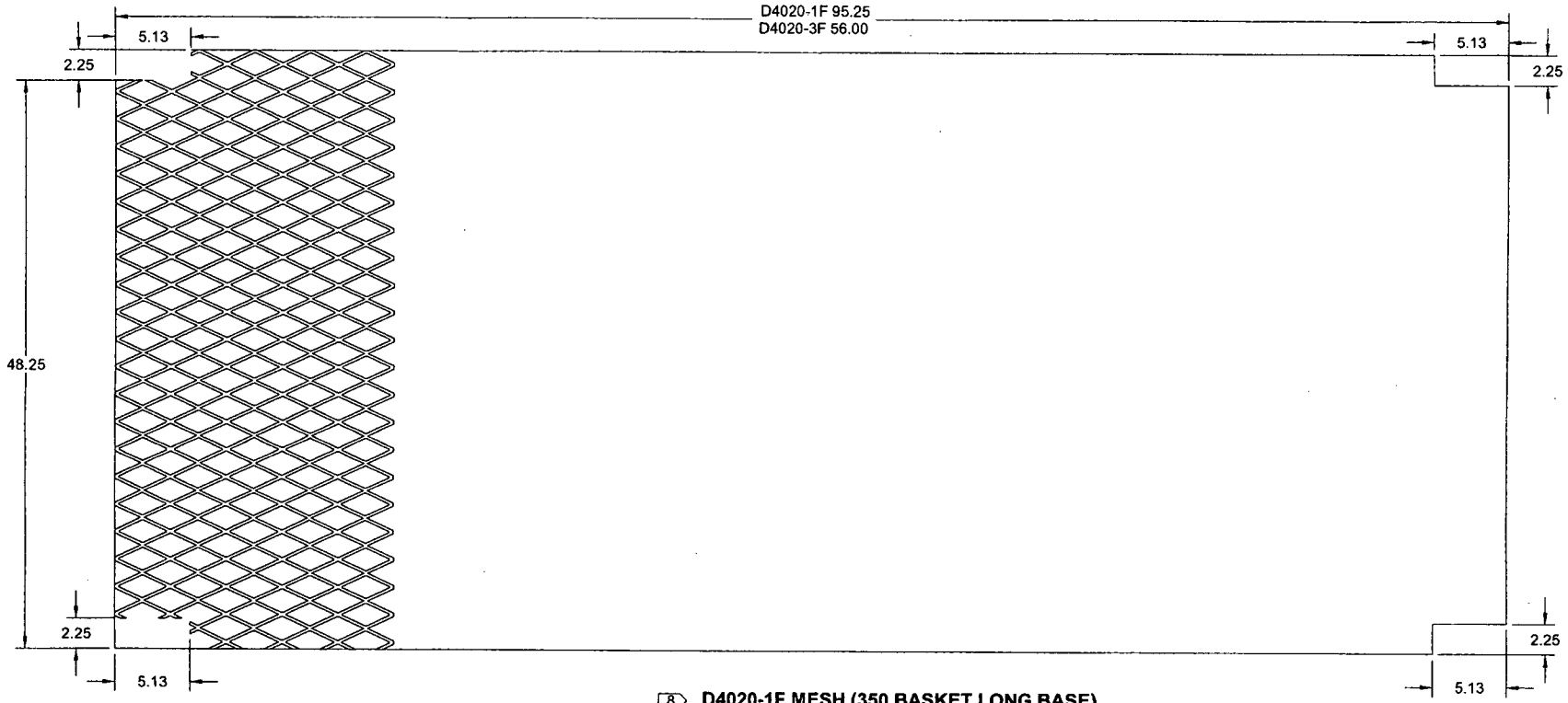
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



8 **D4020-1F MESH (350 BASKET LONG BASE)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

8 **D4020-3F MESH (350 BASKET SHORT, BASE)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010 -03- 12

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -1F: 17.33 lbs APPROX
-3F: 10.16 lbs APPROX
8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D4020 — REV. A — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE 350 BASKET MESH (BASE) — SCALE NTS
DE APPR.		
DATE	10.03.04	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72223
Description: End Mesh, Basket	Part Number:	D4020-11
Inspection Dwg: D4020 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.34	+/-0.030	24.31	—		RA04	TAPE
2.88	+/-0.030	2.88	—		"	
17.31	+/-0.030	17.30	—		"	
15.50	+/-0.030	15.50	—		"	
20.18	+/-0.030	20.17	—		"	

Measured by:		Audited by:	for MW	Preliminary Approval:	N/A
Date:	11/07/20	Date:	11/08/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.08.03	Dimensions updated	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries